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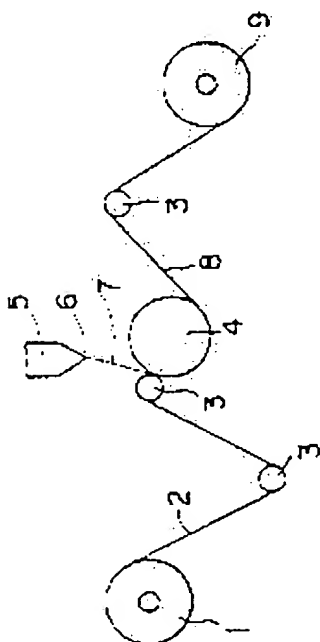
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## (54) MANUFACTURE OF THERMOPLASTIC RESIN FILM WITH RELEASE SHEET



(57)Abstract:

PURPOSE: To enable to obtain film with excellent accuracy of thickness without employing solvent or applying rolling by a method wherein thermoplastic resin is extruded from an extruder employing a gear pump onto a release sheet in order to laminate the resin to the sheet.

CONSTITUTION: A release sheet 2 pulled out of a feed roll 1 is properly changed its running direction by guide rolls 3... and led to a cooling roll 4. Molten thermoplastic resin film 7, which is extruded through the extrusion orifice 6 of a T-die 5 by means of an extruder employing a gear pump, is coated onto the surface of the release sheet at the location just before the sheet abuts against the cooling roll 4 and cooled and solidified by the cooling roll 4. The resultant laminated sheet 8 is changed its running direction by a guide roll 3 and taken up by a winding roll 9. Because the resin film layer of the laminated sheet 8 is pressingly abutted against the surface of the cooling

roll 4 under a certain tension and cooled and solidified, the resin film with desired thickness is laminated onto the surface of the release sheet and wound up without the generation of wrinkles and sagging.

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## LEGAL STATUS

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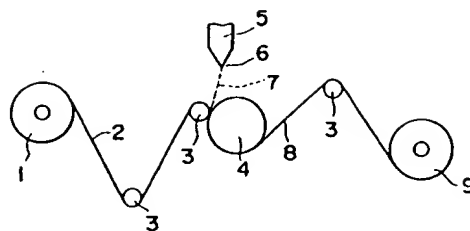
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第 1 図



第 2 図

